

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012197**Date Inspected:** 16-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** As identified below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

North of Bay 14-

Caltrans Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 7EW welds. During visual inspection Caltrans QA observed distortion of FL2-1 flange to web welds, two (2) Longitudinal Linear Indications (LLI) were observed on sub-assembly FL1 floor beam weld FB015-017-001 and FL2-1 weld FB003-067-005 flange to web 6 mm fillet welds, FB015-017-001 (LLI-40 mm in length) and FB003-067-005 (LLI-50mm in length). The "Y" location indications, measured from the W4 line is approximately 4500mm for weld FB015-017-001 and 12830mm for weld FB003-067-005. The indications were discovered visually and confirmed by Magnetic Particle Testing (MT) by Caltrans QA. ZPMC QC stated that Critical Weld Repair Report would be submitted to Caltrans Engineering for approval.

Bay 14-

This QA Inspector observed the following work in progress: Submerged Arc Welding (SAW) of OBG Segment 12AE bottom panel BP3001A to BP3002A Complete Joint penetration (CJP) welds, SEG3001A-008. ZPMC welder was identified as 044771. ZPMC QC is identified as Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-L2c-S-2.

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Flux Cored Arc Welding (FCAW) of OBG Segment 11DE deck panel diaphragm to U rib welds, DP484-001-100 and 105. ZPMC welder was identified as 048038. ZPMC QC is identified as Zhong Guo Hui. ZPMC CWI was identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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